

May-07-15 3:01:51 PM

132619

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Cushion

Start Date: 5/16/15 **Start Qty:** 40.00

40

Cust Item ID:

Required Date: 5/16/15 **Req'd Qty:** 40.00

40

Customer:

Reference:

Approvals: Process Plan: MLJ Date: MAY 08 2015

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4012	C

100

0.00

100

HAAS 1

HAAS CNC vertical machine #1

Memo

Mill as per folio FA889

0.00

Folio rev: AA

Dwg. rev: C

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

40 ~~8~~ JFC 2015-05-17
MJP
15/05/21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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OTHER :																																																																				

Work Order ID 132619

132619

Page 2

May-07-15 3:01:51 PM

Item ID: D4012-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cushion

Start Date: 5/16/15

Start Qty: 40.00

40

Cust Item ID:

Required Date: 5/16/15

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

40

Ø

DAS
40
9-89

15/05/21

130

Identify as per dwg & Stock Location: St 545

0.00

130

Packaging

Memo

0.00

Packaging

40

DAS
6
9-89

MAY 25 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

ML5

MAY 25 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
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OTHER : ☐					

Picklist Print

May-07-15 3:01:50 PM

Page 1

Work Order ID: 132619

132619

Parent Item: D4012-1

D4012-1

Parent Item Name: Cushion

Start Date: 5/16/15

Required Date: 5/16/15

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP RevA: New issue 09.10.28 DD verified by:JLM
revA as per dwg 09.11.18 DD verified by:JLM
as per dwg Rev.B DD verified by:JLM

IPP RevB:
IPP Rev:C 11.01.10

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-3		Manufactured	No			100	f	37.9640	0.37	15.57895			

D4287-3

Uhmw U-Channel

Location

Loc Qty

Loc Code

ST479a

37.964

131216

37.964

132385

5.0 ft } JHL 2015-05-17
10.57 ft

DQA: _____ Date: _____

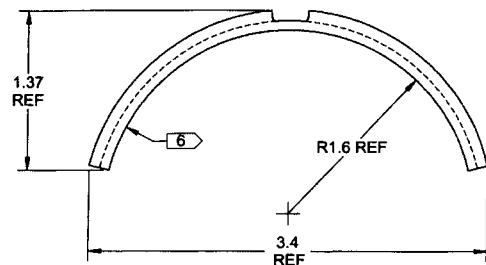


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

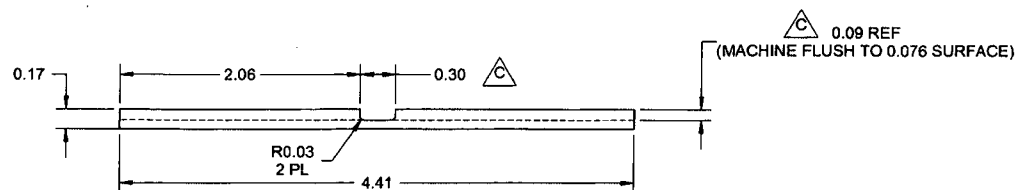
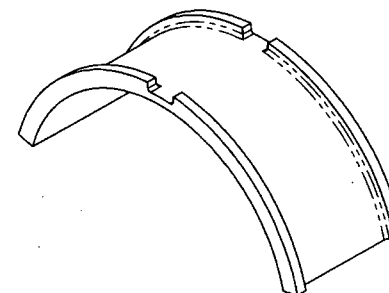
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Cuffs ☐																																																																				
Crushing ☐																																																																				
Heat Treat ☐																																																																				
Wave/Twist in Tube ☐																																																																				
Marks/Chatter ☐																																																																				
Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																		
Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																		
BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																		
Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																		
Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																		
Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																		
Countersink ☐	Off-set ☐	Drawing ☐																																																																		
Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																		
Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																		
Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																		
OTHER : ☐																																																																				

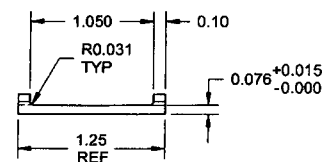


D4012-1 CUSHION
(MAKE FROM D4012-1F)
(COLD FORMED DURING INSTALLATION, DIMS REFERENCE ONLY)

132615-ULS
150508



D4012-1F FLAT MACHINED STATE 1



- NOTES:
- 1) MATERIAL: MAKE FROM D4287-3
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4012-1" AND B/N "BXXXXX" PER QSI 044 6.1
 - 7) WEIGHT: 0.02 lbs

RELEASED

2015 MAR 26
ECN 15-532

C	ADD 0.30 NOTCH, 2 PL, ADD COLD FORM NOTE, REF DIMS FOR D4012-1 REASON: PAR 14-331, NCR 14-3521	DB	14.09.22
B	CHANGED RAW MATERIAL TO REDUCE MANUFACTURING COSTS; PART NOW MACHINED FLAT AND SHAPED WITH RADIUS. REF: PAR10-29	MB	10.12.07
A	NEW ISSUE	MB	09.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4012	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	CUSHION	NTS
DATE	14.09.22	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	